

Work Order ID **76790*****76790***

Page 1

November-21-11 11:12:40 AM

Item ID: D2680-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate

Start Date: 21/11/2011 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/01/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: M.L.S Date: 11/11/21

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2680

Rev B1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2680 Dwg Rev: B1 Prog Rev: B1 2-
Deburr if necessary

1010.063

B11-12-12

(96)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-12-12

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8 u12/13count
(96)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76790

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November-21-11 11:12:40 AM

Item ID: D2680-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate
 Start Date: 21/11/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2-C'sink as per Dwg D2680								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8:50</u> OVEN TEMPERATURE: <u>9:20</u>								
	FINISH TIME: <u>3200E</u>								

W4480

3200E

9:20

9/11/12 / 19 (96)

count
(x96)
QSP019

96x8 M-4 11/12/123

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76790

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 21/11/2011 **Start Qty:** 50.00 ***50***

Cust Item ID:

Required Date: 10/01/2012 **Req'd Qty:** 50.00 ***50***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

96x q III K(2/27)
COUNTED

0.00

170

Small Fab

0.00

Small Fab

Memo

Small Fab

Install Nut Plate as per Dwg D2680

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

5/17/28

EB 11/12/28

counts
x%

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/01/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: 19

0.00

190

Packaging

Memo

0.00

Packaging

11/12/08 (94)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

CK 12/01/0211-12-29
(94)

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Picklist Print

November-21-11 11:12:44 AM

Page 1

Work Order ID: 76790

76790

Parent Item: D2680-041

D2680-041

Parent Item Name: Nut Plate

Start Date: 21/11/2011

Required Date: 10/01/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4		Purchased	No			110	Each	340.0000	1	50			
MS21069L 4									**				
Nutplate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				340					
				106285				140					
				119042				200					
M1010S16GA		Purchased	No			170	sf	87.5000	0.0131	0.689474			
M1010S16GA									**				
1010/1025 Sheet 16GA													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT019				87.5					
				116791				27.4					
				117500				28.1					
				118965				32					
MS20426AD3-3		Purchased	No			170	Each	3,905.000	2	100			
MS20426AD3-3									**				
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				3905					
				119109				3000					
				19099				905					

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DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED P	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE	SCALE 1:1	
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

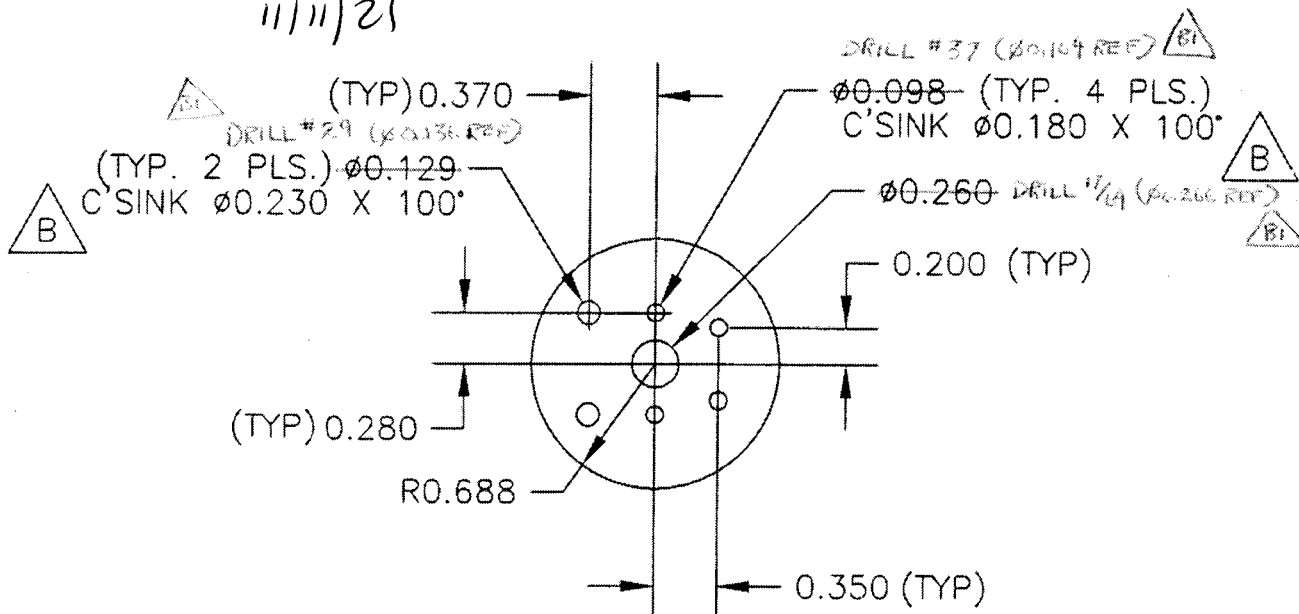
NO. 76790 M.L.S

11/11/21

D2680-1
INSTALL WITH MS20426AD3-3 RIVETS

MS21069L4 NUT PLATE

D2680-041



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

POWDER COAT WHITE (475.2) PER DART QSI 005 4.3
D2680-1

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